

Date: Friday, 6/23/2006 2:37:33 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACERS (5/16 THICK)
Job Number : 25967
Estimate Number : 10248
P.O. Number : N/A Part Number : D2022103
This Issue : 6/23/2006 S.O. No. : N/A Drawing Number : D2022 REV. --
Prsht Rev. : NC Project Number : N/A
First Issue : 2/27/2006 Type : MACHINED PARTS Drawing Revision : --
Previous Run : Material : N/A
Written By : SEE COMMENT BEKW Due Date : 3/20/2006 Qty: 100 Um: Each
Checked & Approved By :
Comment : Est D 02.03.07 Now made in house NG

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0750 6061-T6 Round Bar .750"



Comment: Qty.: 0.0329 f(s)/Unit Total : 3.2865 f(s)
6061T6 Round Bar .750"

Material: 6061-T6 (QQ-A-225/8)x.7500 bar
(M6061T6R0.750) Batch: M100559 606" MS 06/06/25

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1- Note: .323 (P) Dia drill.

2-Turn Blank as per FolioFA207

3-Tumble & deburr any sharp edges as per dwg

SAD 06:07:02 181
M.F. 06/06/30
MS 06/06/25 183

(182)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/06/25 183

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S.G 06/07/07 181

(181)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5717

06/07/07 (181)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 6/23/2006 2:37:34 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACERS (5/16 THICK)

Job Number: 25967

Part Number: D2022103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SP 06/07/07

Job Completion



11 06-07-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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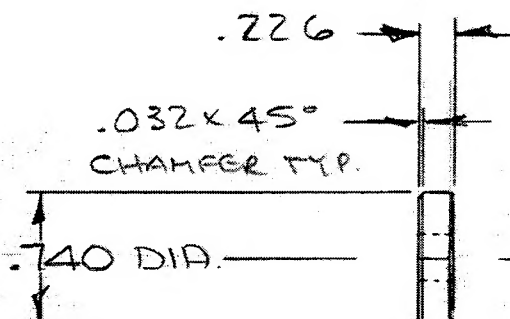
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

RELEASED
970119 BW

REFERENCE ONLY



DRILL 'F' (.257) DIA. IN -101
DRILL P (.323) DIA IN -103

D2022-101
D2022-103

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/B)



D2022

D2022-103		SPACER 5/16 ALUM 6061-T6	QQ-A-250/B	
D2022-101		SPACER 1/4 ALUM 6061-T6	QQ-A-250/B	
PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 623		QTY. REQUIRED	APPROVAL		CONTRACT NO.		DART AERO ACCESSORIES INC	
DRAWN			BASIC CODE	DIA. DASH NO. IN-HEAD NEAR SIDE P-HEAD FAR SIDE				DESIGNER	DATE	CLIENT	
APPROVED			D-DIMPLE D-DIMPLE OF SHEETS C-COUNTERSINK	LENGTH DASH NO. IN-SPOTWELD				DESIGN	400813		
DESCRIPTION OF CHANGE	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		BASIC CODES				STRESS		TITLE		REV.
	GENERAL		BASIC CODES				CHECKED		CODE		
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125+ 3. REMOVE SHARP EDGES .015 MAX. 4. THREADS PER ANI - S-7742 5. HOLES PER ANI 10281		1. TOLERANCES - JOL & D30 2. ANGLES JOL & D10 3. 10° 4. PARALLELISM 5. D30S 6. SYMMETRY ABOUT ALL M/C CENTRE LINES D05		BPM520470AD BPM520412AD		CLIENT		DWG NO. D2022		
	REPORT ALL DISCREPANCIES - DO NOT SCALE						SCALE 1:1		SHT 1 OF 1		

